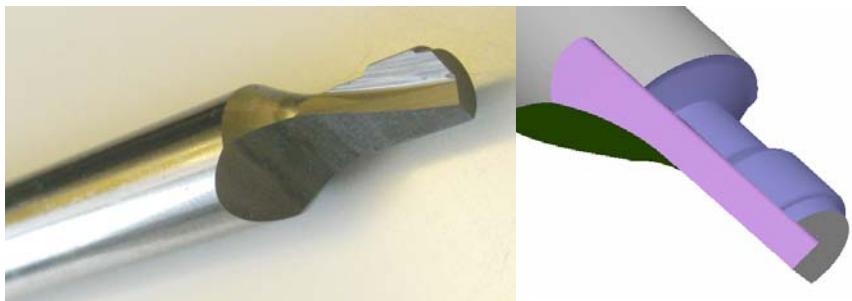


ID-Turning Tool Ø10 Z1

A17-010

The profile of ID-Turning Tools can be ground using either the surface type CS 1 CAM or CS 1 CYL from DXQ Profilegrinding option. The advantage of CS 1 CAM: Turning tools with additional clearance angles can be ground.



1. Cycletime for production

Toolspecifications

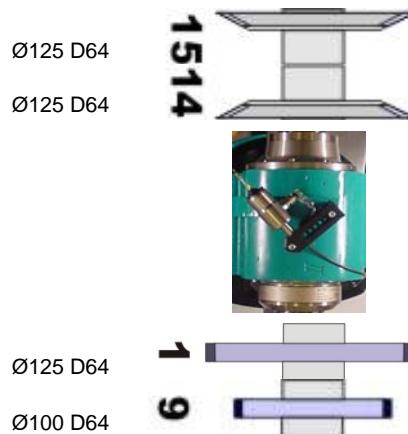
Diameter 10 mm, Cutting edges 1, Length of cutting edge 12 mm, Helix angle 0.001 deg

Material HM

| Operations | Probe | Flute 1 | Flute 2 | Prf Rough | Prf Pregr | Prf Cyl | Red. from shank |
|--------------------|-----------|---------|---------|-----------|-----------|---------|-----------------|
| Feed [mm/Min] | 2000 | 60 | 100 | 30 | 40 | 3 | 100 |
| Power [kW] | | 4 | 2 | 2 | 1 | 1 | 1 |
| Cutting feed [m/s] | | 18 | 18 | 22 | 24 | 22 | 24 |
| Used wheels | | 9 | 9 | 1 | 9 | 15 | 14 |
| Grinding time [s] | 14 | 31 | 22 | 162 | 114 | 360 | 44 |
| Total cycle time | 12 Min 27 | | | | | | |

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.

2. Used grinding wheels



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, NORMA CFG
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto NT

responsible engineer: O.Pellegrini, 22.01.07

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

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